

Work Order ID 88687

July-30-12 2:33:12 PM

88687

Page 2

Item ID: D3650-1

Revision ID:

Item Name: Aft Panel

Start Date: 7/30/12

Start Qty: 1.00

1

Required Date: 7/31/12

Req'd Qty: 1.00

1

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3650

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D3650

Picklist Print

July-30-12 2:33:12 PM

Page 1

Work Order ID: 88687

Parent Item: D3650-1

Parent Item Name: Aft Panel

Start Date: 7/30/12

Required Date: 7/31/12

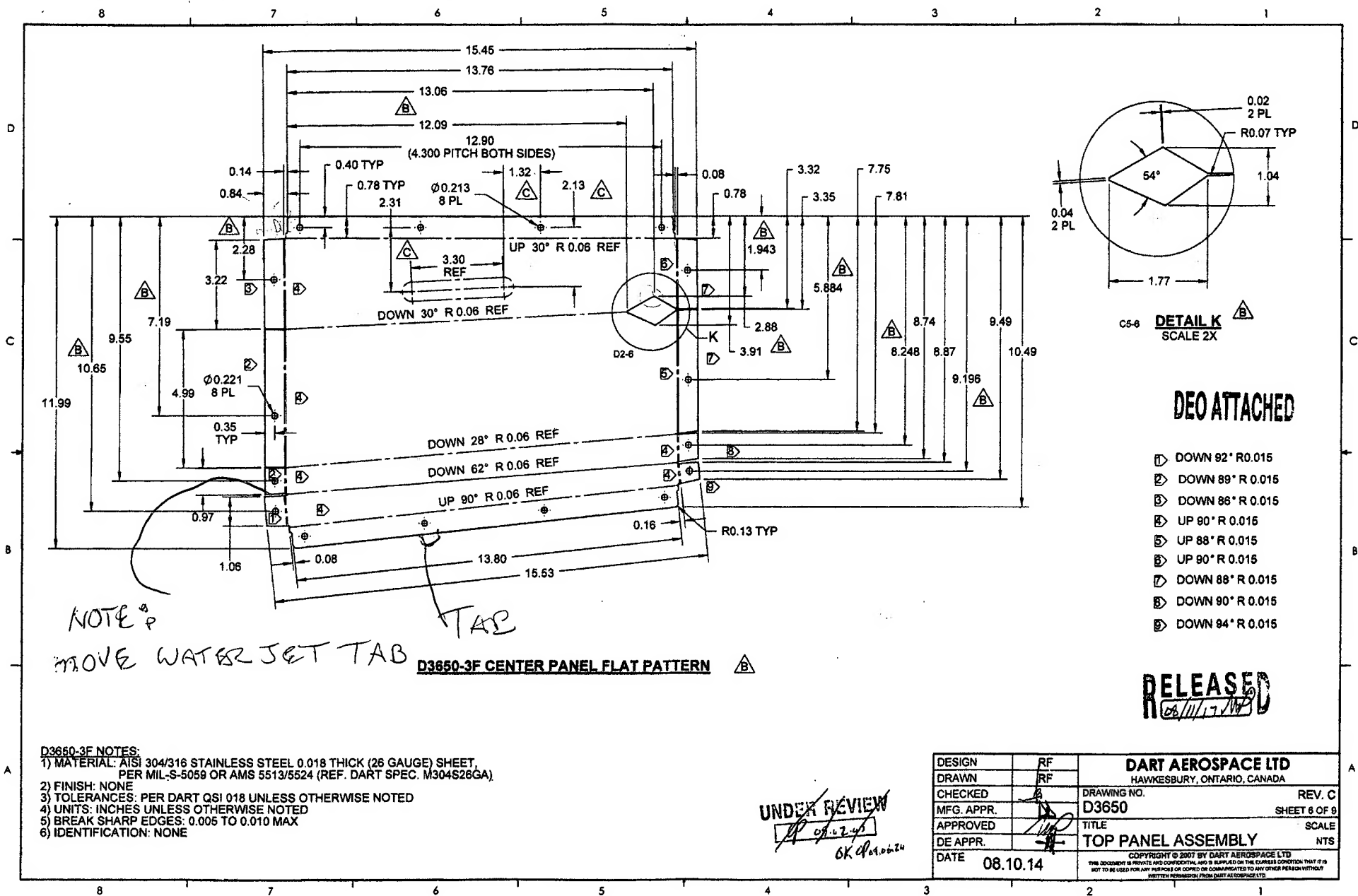
Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD verified by: EC
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased	No			150	sf	74.2500	1.583	1.6663158			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		74.25							
				117798		74.25				117798			
MS20427M3-3 Rivet		Purchased	No			150	Each	1,077.0000	18	18			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		1074							
				121114		1074							
				ST318		3							
				120930		3							
MS21060-3K Nut Plate		Purchased	No			150	Each	111.0000	6	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		111							
				116857		17							
				117423		13							
				117977		50							
				118267		31							
MS21062-3K Nut Plate		Purchased	No			100	Each	102.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				317		50							
				122452		50							
				ST302		52							
				109590		4							
				117343		48							





Jm 12-7-30



D3650-3F NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE

UNDER REVIEW

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3650	SHEET 6 OF 9
APPROVED		TITLE	SCALE
DE APPR.		TOP PANEL ASSEMBLY	NTS
DATE	08.10.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROVIDED AS CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order: 88687
Description: aft panel		Part Number: 03650-1
Inspection Dwg: 03650 Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.45	± 0.030	15.45	✓		MT	
13.76	± 0.030	13.78	✓		MT	
13.06	± 0.030	13.08	✓		MT	
12.09	± 0.030	12.09	✓		MT	
0.40 Typ	± 0.030	0.40	✓		✓	
0.78 Typ	± 0.030	0.78	✓		✓	
0.213	± 0.005 ± 0.001	0.213	✓		✓	
1.32	± 0.030				✓	REWA DIM
0.78	± 0.030	0.78	✓		✓	
3.32	± 0.030	3.326	✓		MT	
3.35	± 0.030	3.36	✓		MT	
7.75	± 0.030	7.75	✓		MT	
7.81	± 0.030	7.87	✓		MT	
1.943	± 0.010	1.952	✓		MT	
5.884	± 0.010	5.889	✓		MT	
8.248	± 0.010	8.248	✓		MT	
8.74	± 0.030	8.75	✓		MT	
8.87	± 0.030	8.874	✓		MT	
9.196	± 0.010	9.199	✓		MT	
9.49	± 0.030	9.500	✓		MT	
10.49	± 0.030	10.500	✓		MT	
12.90	± 0.030	12.90	✓		MT	

Measured by: Smb
Date: 12.7.31

Audited by: SPR 29
Date: 12/07/31

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART AEROSPACE LTD		Work Order: 88687
Description: aft panel		Part Number: 13650-1
Inspection Dwg: 13650	Rev:	Page: 1 of 3

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.88	± 0.030	2.88	✓		MT	
3.91	± 0.030	3.91	✓		MT	
RO 13 TYP						
0.16	± 0.030	0.166	✓		✓	
13.80	± 0.030	13.81	✓		MT	
15.53	± 0.030	15.535	✓		MT	
0.08	± 0.030	0.08	✓		✓	
1.06	± 0.030	1.064	✓		✓	
0.97	± 0.030	0.974	✓		✓	
0.35 TYP	± 0.030	0.35	✓		✓	
0.221	± 0.010	0.220	✓		MT	
11.99	± 0.030	11.995	✓		MT	
10.65	± 0.030	10.655	✓		MT	
9.55	± 0.030	9.55	✓		MT	
7.19	± 0.030	7.195	✓		MT	
3.22	± 0.030	3.23	✓		MT	
4.99	± 0.030	4.99	✓		MT	
2.28	± 0.030	2.29	✓		MT	
0.14	± 0.030	0.144	✓		✓	
0.84	± 0.030	0.845	✓		✓	
3.30 Ref	± 0.030					
1.77	± 0.030	1.772	✓		✓	
1.04	± 0.030	1.041	✓		✓	

Measured by: Smb
Date: 12-7-31

Audited by: SBL
Date: 12/01/31

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

